

GUHRING Ratio drill without oil feed type 5615

Design: Ultra-fine grain-solid carbide, DIN 6537, type RT 100 U.

Fire coated surface, right cutting with special point geometry and ratio point thinning. Normal angle of rake, core thickness thicker than normal and without core gradient. The drill has a very good self-centring behaviour and produces short chips, even from long-chipping materials.



Carbide application group: K/P ?universal use.
[Ultra-fine grain K05?K50/P05?P50]

Application: For accurate alignment drilling with narrow Ø tolerances and good surfaces. Suitable for drilling holes up to 5 x D with high cutting values. Particularly suitable for long and short-chipping materials such as construction and case-hardening steels, steel castings, tempered steels, carbon steels, bronzes, castings, high alloy AISi alloys and alloy steels up to 1200 N/mm² in strength.

Note: The drills can be sharpened and recoated several times.

Characteristics

Cutting direction: Right

DIN standard: 6537L

Type: Twist drill

Coating: nanoFIRE

Point angle: 140 °

Diameter mm	Cutting length mm	Total length mm	Holding system	Material	Article
3.1	28	66	Whistle notch	Solid carbide	W90A-12150310
3.2	28	66	Whistle notch	Solid carbide	W90A-12150320
3.4	28	66	Whistle notch	Solid carbide	W90A-12150340
3.6	28	66	Whistle notch	Solid carbide	W90A-12150360
3.9	36	74	Whistle notch	Solid carbide	W90A-12150390
4.1	36	74	Whistle notch	Solid carbide	W90A-12150410
4.3	36	74	Whistle notch	Solid carbide	W90A-12150430
4.4	36	74	Whistle notch	Solid carbide	W90A-12150440
4.65	36	74	Whistle notch	Solid carbide	W90A-12150465
4.7	36	74	Whistle notch	Solid carbide	W90A-12150470
4.9	44	82	Whistle notch	Solid carbide	W90A-12150490
5.1	44	82	Whistle notch	Solid carbide	W90A-12150510
5.2	44	82	Whistle notch	Solid carbide	W90A-12150520
5.3	44	82	Whistle notch	Solid carbide	W90A-12150530
5.4	44	82	Whistle notch	Solid carbide	W90A-12150540
5.55	44	82	Whistle notch	Solid carbide	W90A-12150555
5.6	44	82	Whistle notch	Solid carbide	W90A-12150560
5.7	44	82	Whistle notch	Solid carbide	W90A-12150570
5.9	44	82	Whistle notch	Solid carbide	W90A-12150590
6.1	53	91	Whistle notch	Solid carbide	W90A-12150610
6.2	53	91	Whistle notch	Solid carbide	W90A-12150620
6.3	53	91	Whistle notch	Solid carbide	W90A-12150630
6.4	53	91	Whistle notch	Solid carbide	W90A-12150640
6.6	53	91	Whistle notch	Solid carbide	W90A-12150660
6.7	53	91	Whistle notch	Solid carbide	W90A-12150670
6.9	53	91	Whistle notch	Solid carbide	W90A-12150690
7.1	53	91	Whistle notch	Solid carbide	W90A-12150710
7.2	53	91	Whistle notch	Solid carbide	W90A-12150720

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Diameter	Cutting length	Total length	Holding system	Material	Article
mm	mm	mm			
7.3	53	91	Whistle notch	Solid carbide	W90A-12150730
7.6	53	91	Whistle notch	Solid carbide	W90A-12150760
7.7	53	91	Whistle notch	Solid carbide	W90A-12150770
7.9	53	91	Whistle notch	Solid carbide	W90A-12150790
8.1	61	103	Whistle notch	Solid carbide	W90A-12150810
8.2	61	103	Whistle notch	Solid carbide	W90A-12150820
8.3	61	103	Whistle notch	Solid carbide	W90A-12150830
8.4	61	103	Whistle notch	Solid carbide	W90A-12150840
8.6	61	103	Whistle notch	Solid carbide	W90A-12150860
8.7	61	103	Whistle notch	Solid carbide	W90A-12150870
8.9	61	103	Whistle notch	Solid carbide	W90A-12150890
9.1	61	103	Whistle notch	Solid carbide	W90A-12150910
9.2	61	103	Whistle notch	Solid carbide	W90A-12150920
9.25	61	103	Whistle notch	Solid carbide	W90A-12150925
9.4	61	103	Whistle notch	Solid carbide	W90A-12150940
9.6	61	103	Whistle notch	Solid carbide	W90A-12150960
9.7	61	103	Whistle notch	Solid carbide	W90A-12150970
9.9	61	103	Whistle notch	Solid carbide	W90A-12150990
10.1	71	118	Whistle notch	Solid carbide	W90A-12151010
10.3	71	118	Whistle notch	Solid carbide	W90A-12151030
10.32	71	118	Whistle notch	Solid carbide	W90A-12151032
10.4	71	118	Whistle notch	Solid carbide	W90A-12151040
10.6	71	118	Whistle notch	Solid carbide	W90A-12151060
10.7	71	118	Whistle notch	Solid carbide	W90A-12151070
10.8	71	118	Whistle notch	Solid carbide	W90A-12151080
10.9	71	118	Whistle notch	Solid carbide	W90A-12151090
11.1	71	118	Whistle notch	Solid carbide	W90A-12151110
11.11	71	118	Whistle notch	Solid carbide	W90A-12151111
11.2	71	118	Whistle notch	Solid carbide	W90A-12151120
11.3	71	118	Whistle notch	Solid carbide	W90A-12151130
11.4	71	118	Whistle notch	Solid carbide	W90A-12151140
11.6	71	118	Whistle notch	Solid carbide	W90A-12151160
11.7	71	118	Whistle notch	Solid carbide	W90A-12151170
11.8	71	118	Whistle notch	Solid carbide	W90A-12151180
11.9	71	118	Whistle notch	Solid carbide	W90A-12151190
11.91	71	118	Whistle notch	Solid carbide	W90A-12151191
12.2	77	124	Whistle notch	Solid carbide	W90A-12151220
12.7	77	124	Whistle notch	Solid carbide	W90A-12151270
13.7	77	124	Whistle notch	Solid carbide	W90A-12151370
14.2	83	133	Whistle notch	Solid carbide	W90A-12151420
14.29	83	133	Whistle notch	Solid carbide	W90A-12151429
14.7	83	133	Whistle notch	Solid carbide	W90A-12151470
15.2	83	133	Whistle notch	Solid carbide	W90A-12151520
15.7	83	133	Whistle notch	Solid carbide	W90A-12151570
16.5	93	143	Whistle notch	Solid carbide	W90A-12151650
17	93	143	Whistle notch	Solid carbide	W90A-12151700
17.5	93	143	Whistle notch	Solid carbide	W90A-12151750
18	93	143	Whistle notch	Solid carbide	W90A-12151800
18.5	101	153	Whistle notch	Solid carbide	W90A-12151850
19	101	153	Whistle notch	Solid carbide	W90A-12151900
19.5	101	153	Whistle notch	Solid carbide	W90A-12151950
20	101	153	Whistle notch	Solid carbide	W90A-12152000

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